

Work Order ID 73023

Wednesday, August 24, 2011 8:57:39 AM

ship Oct-14



Page 1

Item ID: D350-591-312

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step, Long RH

Start Date: 8/24/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3272

Rev B

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

5/11/10/14

AGS MLS 11-10-13 (10)

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod

3-Grind End Plate flush

117884
114514

11-09-23 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector*

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73023

Page 2

Wednesday, August 24, 2011 8:57:39 AM

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Setup Start



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Stop



Item Name: Heli-Access-Step, Long RH

Start Date: 8/24/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
-----	--	------	--	--	--	--	--	--	--



QC	Memo	0.00							
----	------	------	--	--	--	--	--	--	--

Quality Control

x10 @ JE 11/10/04

130	QC5- Inspect part completeness to step on W/O	0.00							
-----	---	------	--	--	--	--	--	--	--



QC	Memo	0.00							
----	------	------	--	--	--	--	--	--	--

Quality Control

5 11/10/04



140	Chemical Conversion Coat per QSI005 4.1	0.00							
-----	---	------	--	--	--	--	--	--	--



HandFinish	Memo	0.00							
------------	------	------	--	--	--	--	--	--	--

Hand Finishing

10 x 11/10/04
RH

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Required Date: 10/14/2011 Req'd Qty: 10.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

11-10-07

10

φ

180

Large Fab

0.00



Large Fab

Memo

0.00

Large Fab

10

φ

1-Assemble Leg Assembly as per Dwg D3272.

2-Leave one rivet out until welding is complete.

3-Bevel Aft end for welding

4-Inspect for foreign object as per QSI 024

5-Weld Aft End Plate as per QSI 004 & Dwg D3272
A/R: Aluminum Rod 114514

6-Grind End Plate flush

7-Install last rivet as per Dwg.

11-10-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Powder Coating

Memo

START TIME:

12:00

0.00

OVEN TEMPERATURE:

320 OF

FINISH TIME:

12:45

Wing Walk as per dwg QSI005 4.4 Batch 118313 0.00

230



HandFinish

Hand Finishing

Memo

0.00

240

QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo

0.00

10X Ø M-L 11/10/12

10 BR 11-10-14

10RH of all whole counted

M118439

[illegible]

Page 6

Accept

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Setup Start

Stop

RESEARCH

Cust Item ID:

1. The first step in the process is to identify the problem or issue that needs to be addressed. This involves gathering information and understanding the context of the problem.

2. Once the problem is identified, the next step is to define the objectives and goals of the project. This helps to clarify what needs to be achieved and provides a clear direction for the project.

3. The third step is to develop a plan or strategy to address the problem. This involves identifying the resources needed, the timeline, and the specific actions to be taken.

4. The fourth step is to implement the plan. This involves putting the strategy into action and monitoring progress along the way.

5. Finally, the fifth step is to evaluate the results of the project. This involves assessing whether the objectives were met and identifying any lessons learned for future projects.

Customer:

Reference:

Run Start

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

**Insp.
Stamp**

0.00

Packaging

Memo

0.00

Packaging

0.00

QC

Quality Control

Memo

0.00

0.00

[illegible]

Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPPD350-591-312

Location: Hall

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73023

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Item ID: D350-591-312

Accept



Setup Start



Revision ID:

Item Name: Heli-Access-Step, Long RH

Stop



Start Date: 8/24/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/10/17
MF
11-10-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Picklist Print

Wednesday, August 24, 2011 8:57:36 AM

Page 1

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Work Order ID: 73023

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 8/24/2011


Required Date: 10/14/2011

Start Qty: 10.00


Required Qty: 10.00

Comments: IPP Rev:A 104.03.22 New issue [KJ/RF]
 IPP Rev:B 07-06-09 Added D3572-1 JLM
 IPP Rev:C 08-04-02 ECN1163 DD verified by:EC
 IPP Rev:D 08-04-08 ECN1164 DD verified by:c IPP Rev:D
 fixe route seq in bom DD 10.04.28 verified by:EC


Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3272-1 		Manufactured	No			110	Each	10.0000	1	10		11.09.17	
Step													

Location	Loc Qty	Loc Code
WA 373028	10	
71963	10	

D3067-1 		Manufactured	No			110	Each	54.0000	1	10		11.10.04	
End Plate													

Location	Loc Qty	Loc Code
WA 373404	53	
67582	2	
70700	51	
WA016	1	
68214	1	

D3219-1 		Manufactured	No			110	Each	88.0000	2	20		11.10.04	
Plate													

Location	Loc Qty	Loc Code
WA 72128	48	
WA017	40	
68338	40	



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No IDQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

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Page 2

Work Order ID: 73023

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 8/24/2011

Required Date: 10/14/2011

Start Qty: 10.00

Required Qty: 10.00

D3066-1 Manufactured No

180

Each

87.0000

2

20



Spacer

Location

Loc Qty

Loc Code

WA

B73409

87

70699

87

20

MS20600-AD4W4

Purchased

No

180

Each

1,520.000

16

160



Rivets

Location

Loc Qty

Loc Code

ST321

B118840

1515

116188

59

117364

1000

117601

200

117885

195

118267

61

18

142

WA018

5

116712

5

D3065-041

Manufactured

No

180

Each

0.0000

1

10



Step Leg Assembly Hi

B73292

D3067-1

Manufactured

No

180

Each

54.0000

1

10



End Plate

Location

Loc Qty

Loc Code

WA

B73404

53

67582

2

70700

51

WA016

1

68214

1

10

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Page 3

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Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 8/24/2011

Required Date: 10/14/2011

Start Qty: 10.00

Required Qty: 10.00

AN3-35A

Purchased

No

250

Each

157.0000

Bolt

Location

Loc Qty

Loc Code

ST353

157

117619

3

117794

14

118112

40

118451

50

118628

50

D3235-1

Manufactured

No

250

Each

177.0000

Mounting Lug

Location

Loc Qty

Loc Code

ST471

77

69837

77

ST481

100

71965

100

D3278-041

Manufactured

No

250

Each

26.0000

Support Assembly

Location

Loc Qty

Loc Code

ST471

26

69741

26

AN960JD416

NAS1149D0463J - Purchased

No

250

Each

0.0000

Washer

AN960JD516

NAS1149D0563J - Purchased

No

250

Each

0.0000

Washer

Start Date: 8/24/2011
Start Qty: 10.00
Required Date: 10/14/2011
Required Qty: 10.00
2 20 1x
M118838

2 20
M118838

20 10 62 42
B72132 B73107

16 160 57 101
M118612 M118384
4 40
M118206 11/10/13

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Picklist Print

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Parent Item Name: Heli-Access-Step, Long RH



Start Date: 8/24/2011

Required Date: 10/14/2011

Start Qty: 10.00

Required Qty: 10.00

AN5-36A

Purchased No

250 Each

157.0000

2 20



Bolt



M1180308

Location

Loc Qty

Loc Code

ST341

157

117794

7

118012

50

118451

100

Manufactured No

250 Each

132.0000

2 20

D2618



Bushing



B73408

Location

Loc Qty

Loc Code

ST019

132

70702

28

71600

104

Manufactured No

250 Each

304.0000

4 40

D2230-3



Lug



B73396 11/10/13 100

Location

Loc Qty

Loc Code

ST

220

70694

20

71964

100

72125

100

ST476

4

53881

4

ST480

80

70973

80

1x
7x

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Page 5

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Parent Item Name: Heli-Access-Step, Long RH

Start Date: 8/24/2011

Required Date: 10/14/2011

Start Qty: 10.00

Required Qty: 10.00

D2856-400

Manufactured No

250 f

254.7845

1.2

12



Abraison Strip



11/10/13

Location

Loc Qty

Loc Code

ST403

38.1149

68076

38.1149

ST409

216.6696

63735

0.6696

71164

216

cut (2) D2856-400-720 as per dwg

MS21042L3

Purchased No

250

Each

1,835.000



Nut



Location

Loc Qty

Loc Code

ST300

1835

117441

190

117601

400

117885

245

118451

1000

AN4-13A

Purchased No

250

Each

1,006.000



Bolt



20
8 80
M118706 11/10/13

Location

Loc Qty

Loc Code

ST357

1006

117962

4

118078

594

118350

108

118351

300

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Page 6

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Parent Item Name: Heli-Access-Step, Long RH

Start Date: 8/24/2011

Required Date: 10/14/2011

Start Qty: 10.00

Required Qty: 10.00

MS21042L5
Nut
Purchased No

250 Each

1,153.000

2 20

Location

Loc Qty

Loc Code

ST300

1153

116105

5

116548

53

117441

494

117591

15

117611

90

118179

496

20

MS21042L4
Nut
Purchased No

250 Each

4,539.000

8 80

Location

Loc Qty

Loc Code

ST300

4539

117441

394

117601

645

117885

1500

118451

2000

80

AN960JD10
Washer
Purchased No

250 Each

0.0000

4 40
M118612 11/10/13

Wednesday, August 24, 2011 8:57:36 AM

Shop Packet Print

Page 6



DESIGN <i>GP</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG SCALE NTS	
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED

07.06.04

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

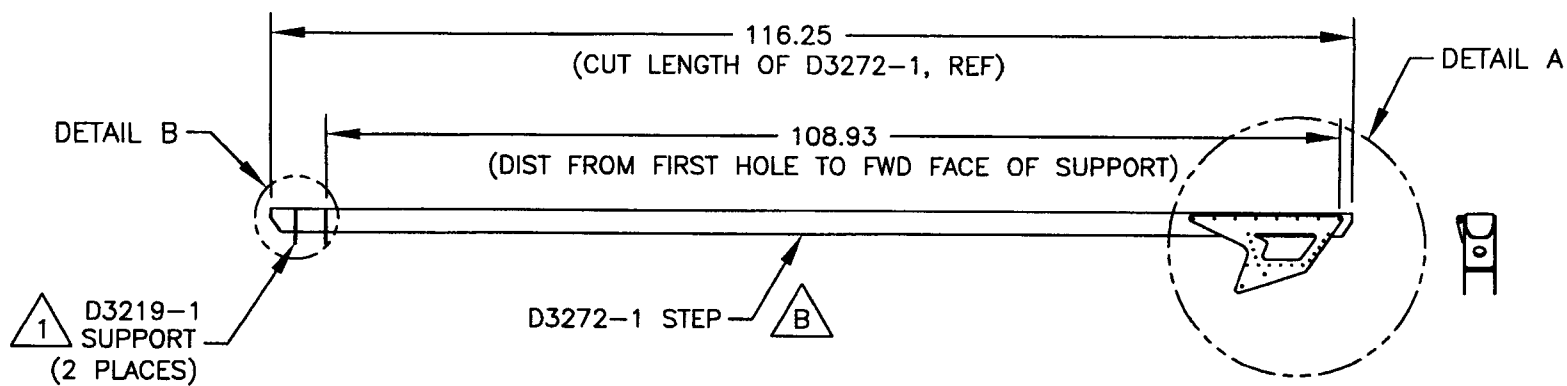
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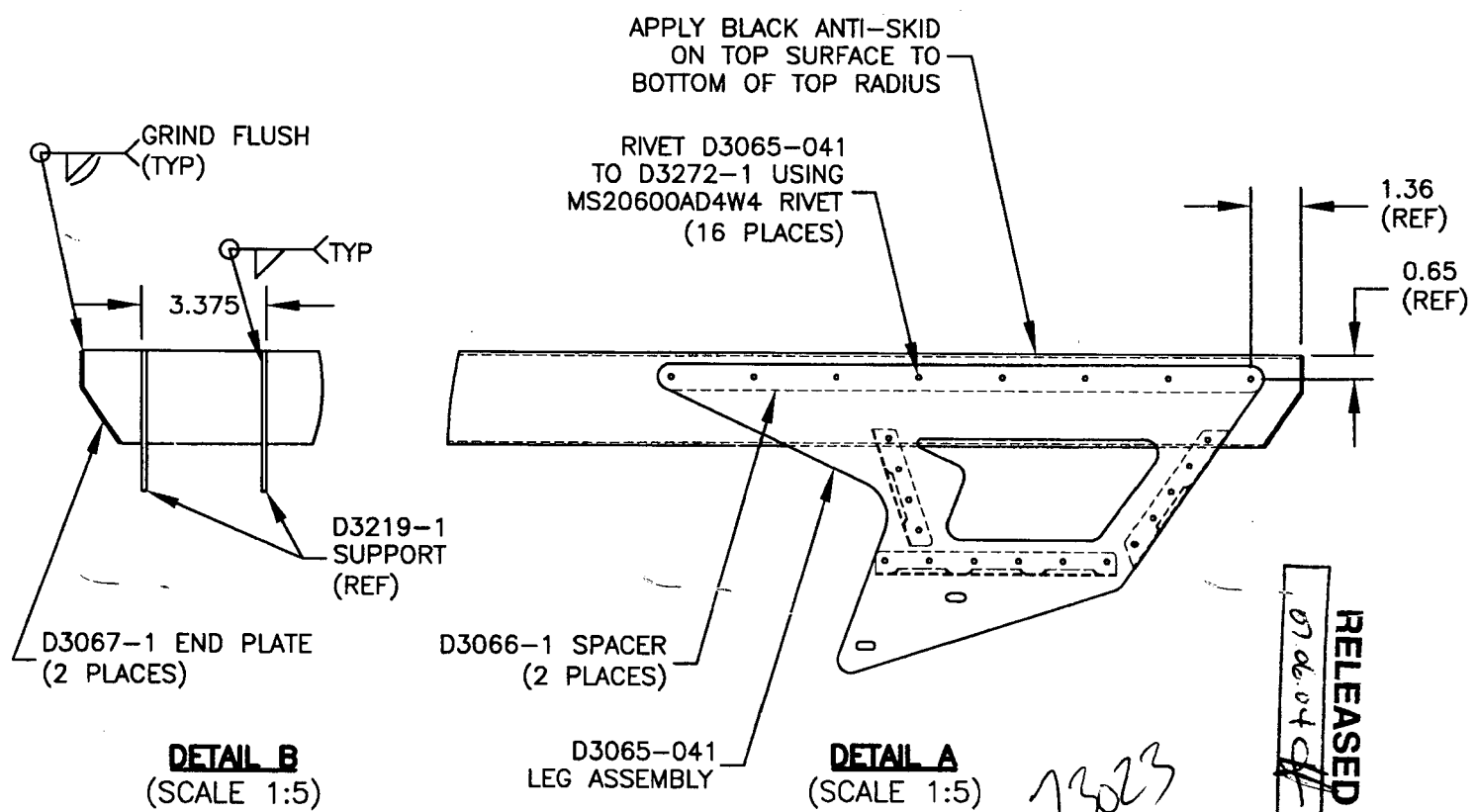
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DESIGN	q	DRAWN BY		DART AEROSPACE LTD
CHECKED	CE	APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	07.05.18	DRAWING NO.	D3272	REV. B
		TITLE	STEP ASSEMBLY, HI LONG	SHEET 2 OF 3
				SCALE 1:20



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



RELEASED
07.06.04

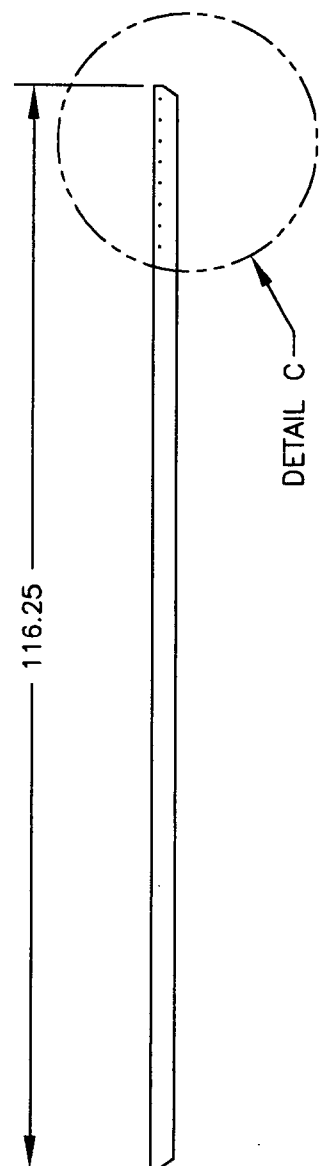
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DESIGN <i>GP</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

RELEASED

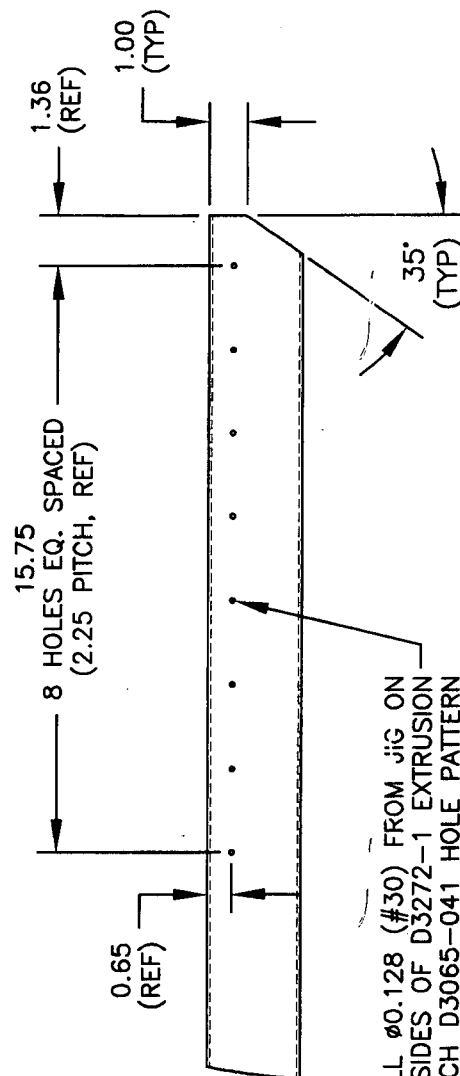
07.06.04 *[Signature]*



DETAIL C

B D3272-1 STEP

(MAKE FROM D2622-120 STEP EXTRUSION)



DRILL $\phi 0.128$ (#30) FROM JIG ON BOTH SIDES OF D3272-1 EXTRUSION TO MATCH D3065-041 HOLE PATTERN

DETAIL C
(SCALE 1:5)

13023

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Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
	X							D350-591-212	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
		X						D350-591-213	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
			X					D350-591-214	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
				X				D350-591-215	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
					X			D350-591-216	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
						X		D350-591-311	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
							X	D350-591-312	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.